

## Abstract

The peripheral length (M) dimension of the outer peripheral surface of drums (35, 36) is set equal to the width (W) dimension of body ply materials (46A, 46B) used for tires or integral multiples thereof. The wrapping length (L) of the wrapper (40) in the direction of the length of the drum is set equal to the length dimension (L1) of the body ply materials (46A, 46B) used for tires.

10 A ribbon (39) of predetermined width E dimension in the form of a cord having a rubber covering applied thereto is produced. The ribbon (39) is spirally wound on the outer peripheral surface of the drums (35, 36) and the lateral edges of the ribbon are bonded together, thus producing  
15 the wrapper (40). The wrapper (40) is cut along a gentle curve which is substantially orthogonal to the direction of the length of the ribbon, thus providing the body ply materials (46A, 46B).